

Date: Friday, 03/11/2006 7:42:26 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 28833
 Estimate Number : 11178
 P.O. Number : N/A
 This Issue : 03/11/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 29240
 Written By :
 Checked & Approved By :
 Comment : Est:A 04.06.24 New issue KJ/JLM
 Est Rev:B Now on Waterjet 06-11-02 JLM

Part Number : D32931
 Drawing Number : D3293 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 10/11/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 1.9177 sf(s)/Unit Total : 7.6709 sf(s) 17.2544
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3293-1
 Batch: 4184P1 ml 06 11 13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3293 ml 06 11 13
 Dwg Rev: A
 Prog Rev: A

SAD 06:01:05

2-Deburr if necessary

SAD 06:11:16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:11:05

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

11/06/13

Date: Friday, 03/11/2006 7:42:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28833

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr

SAV 06.11.26

(4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

YLC FC 06/11/22 X 4

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 11 22 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

ST 108 FC 6/14/23 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 06/11/23 (4)

Job Completion



in 06/11/23

Date: Tuesday, 10/3/2006 2:50:27 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 28833		
Estimate Number	: 11178		
P.O. Number	:	Part Number	: D32931
This Issue	: 10/3/2006 S.O. No. :	Drawing Number	: D3293 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>HA</u>	Due Date	: 10/20/2006 Qty: 4 Um: Each
Checked & Approved By	: <u>HA 06 10 03</u>		
Comment	: Est:A 04.08.24 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 1-9177 sf(s)/Unit Total : 7.6709 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)
Identify for D3293-1
Batch: _____

WAFER

2.0	SHEAR	SHEAR
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Comment: SHEAR
Cut blanks: 20.300" x 11.800"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA444 and Dwg D3293
Stack of 10
Identify as D3293-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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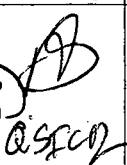
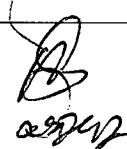
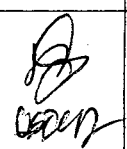

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/06	3	Programme was not good (DXF File From Eng) (Scrap 4)		Destroy and redo	MM 06/11/06	MM 06/11/06		MM 06/11/06
06/11/13	3	5 Scrap DXF From Eng was wrong		Destroy & Redo	MM 06/11/13	MM 06/11/13		MM 06/11/13

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 2:50:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28833

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3293
DATE 04.06.28	TITLE DOUBLER	REV. A SHEET 1 OF 1
A	04.06.28	NEW ISSUE
SCALE 1:3		

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

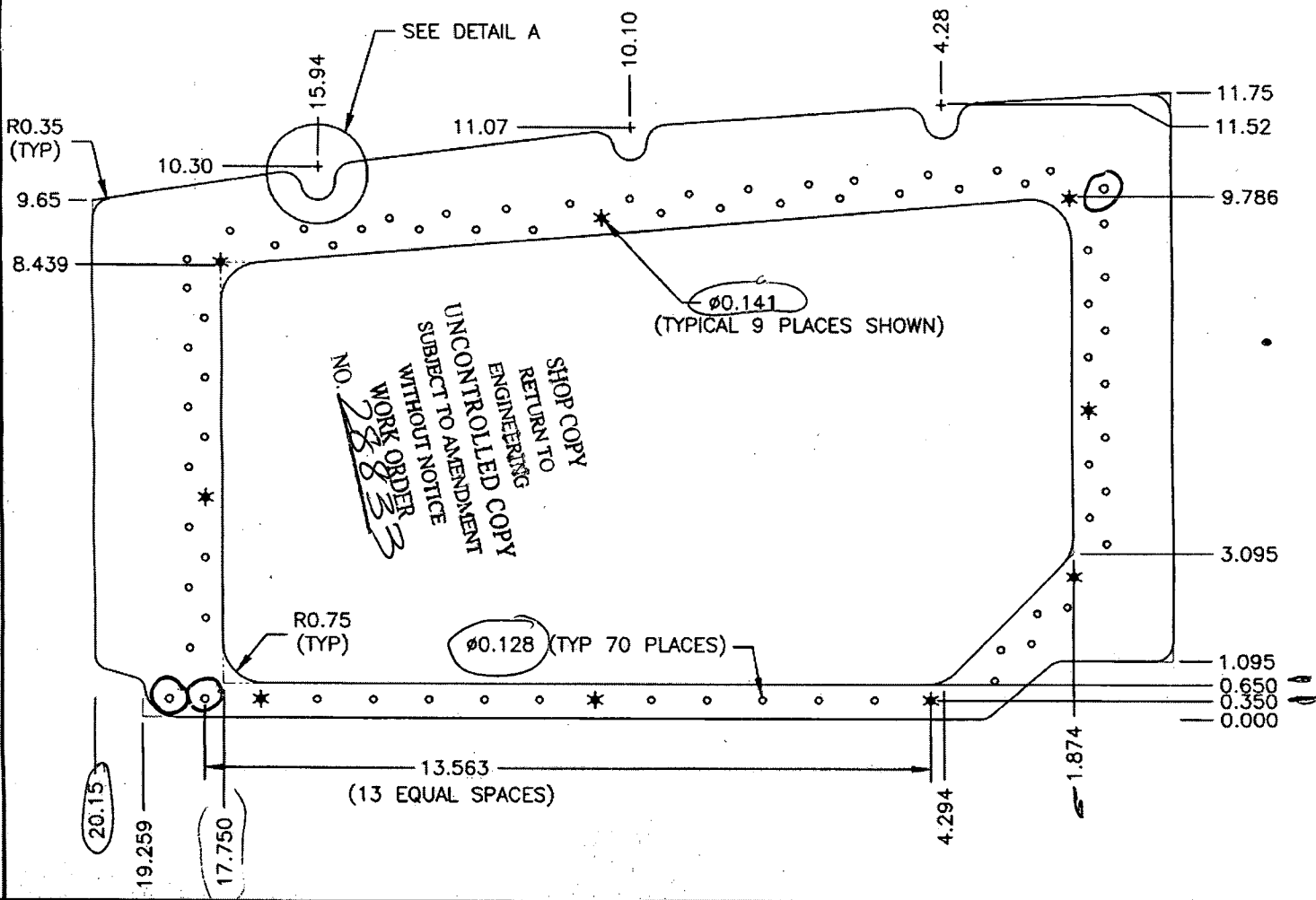
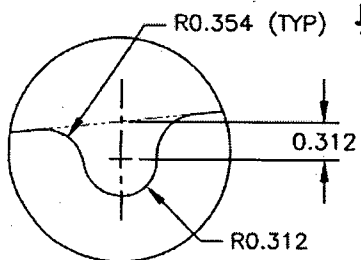
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

DETAIL A
SCALE 2:3



DART AEROSPACE LTD	Work Order: 28833
Description: Doubler	Part Number: D3293-1
Inspection Dwg: D3293 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>M. M.</i>
Date:	<i>8/1/13</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	